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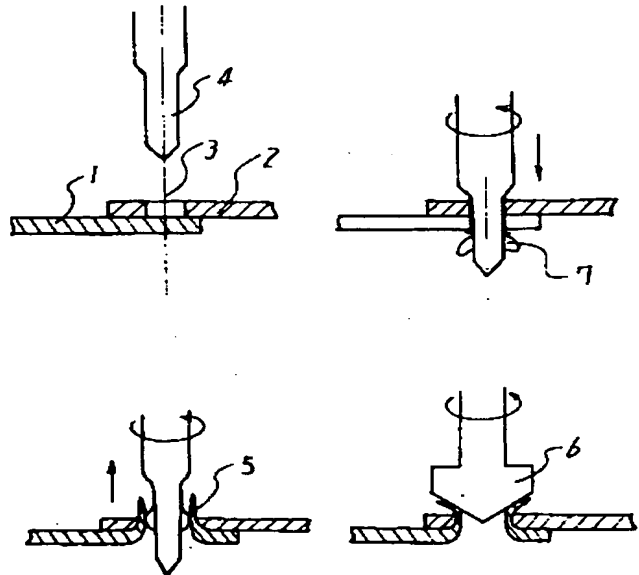
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TITLE : FASTENING METHOD OF METALLIC
PLATE



ABSTRACT : PURPOSE: To fasten spottedly metallic plates at a low cost with a simple binding operation by drilling a hole in the superposed metallic sheets with a burring drill and flaring the burred part to the outside in the form of pulling upward the same in the stage of returning the drill after forming the burred part.

CONSTITUTION: An upper iron plate 2 which is drilled with a hole is superposed on a lower iron plate 1, and the tip of a burring drill 4 is pressed to the center of a hole 3. The drill 4 is rotated at a high speed and is penetrated through the plate 1 to drill a hole therein. The drill 4 expands vanes 7 upon drilling the hole. A burred part 5 is formed in the form of pulling upward the metal around the hole in the stage of pulling up the drill 4 having the expanded vanes 7. The burred part 5 projecting above the plate 2 is flared to the outside by a roll expanding jig 6, by which both plates 1, 2 are fastened. The spot-like fastening of the metallic plates is made possible by the simple binding operation without heating and using any rivet according to the above-mentioned method.

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